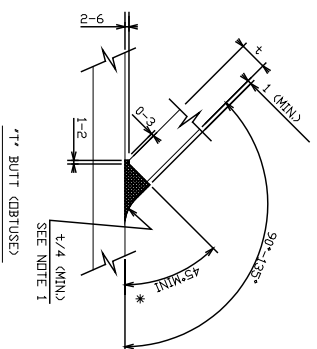
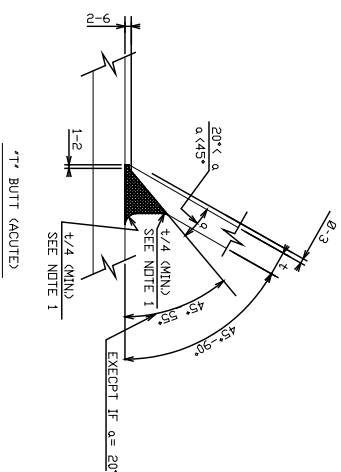


1 DETAIL
SCALE : NONE
T BUTT-PLATE

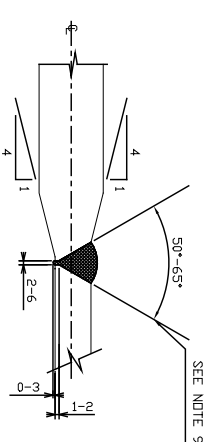


* ANGLE VALUE MANDATORY

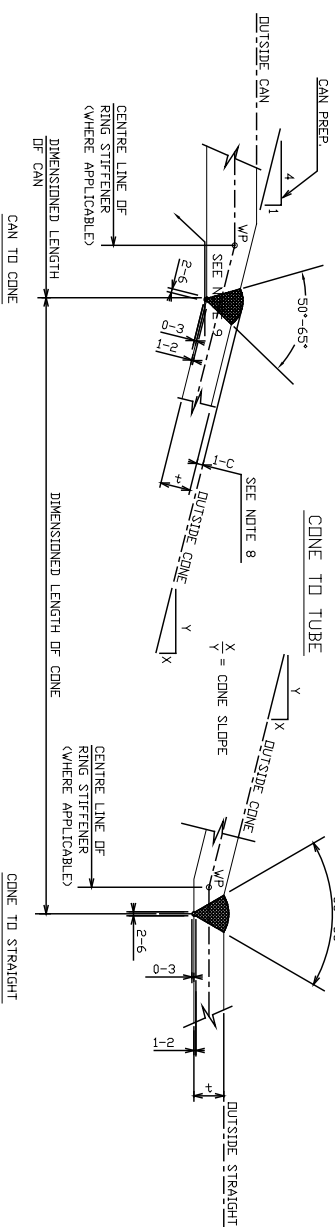


* ANGLE VALUE MANDATORY

2 DETAIL
SCALE : NONE
UNEQUAL THICKNESS BUTT
MATCHING CENTRE LINES
PLATE OR TUBE BUTT



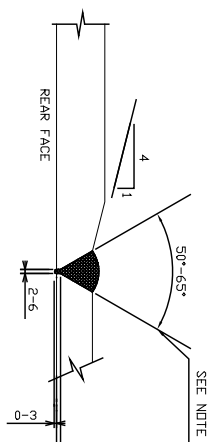
4 DETAIL
SCALE : NONE
CONE TO TUBE



* ANGLE VALUE MANDATORY

* ANGLE VALUE MANDATORY

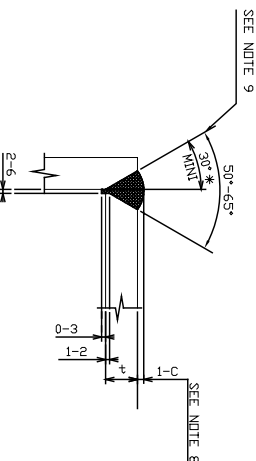
3 DETAIL
SCALE : NONE
UNEQUAL THICKNESS BUTT
MATCHING REAR SURFACE
PLATE OR TUBE



NOTES:
1- WHERE ACCESS IS IMPRACTICAL, DR AS SHOWN ON DESIGN DRAWING, AND AGREED TO BY THE COMPANY/SINGLE SIDED WELDS MAY BE USED AS SHOWN ABOVE.
2- UNLESS NOTED OTHERWISE, ALL STEEL SHALL BE JOINED BY COMPLETE PENETRATION GROOVE WELDS.
3- WELD DETAILS DESCRIBED ON THESE WELDING DETAIL DRAWINGS ARE APPLICABLE UNLESS EXPLICITLY NOTED OTHERWISE IN THE DESIGN DRAWINGS.
4- DETAILS SHOWN ARE APPROPRIATE FOR SMAW OR SAW PROCESSES ONLY. IF OTHER WELDING PROCESSES ARE ALLOWED BY COMPANY DIMENSIONS, ANGLES AND TOLERANCES MAY BE REVISED SUBJECT TO AGREEMENT BY THE COMPANY.
5- DIMENSIONS AND ANGLES OF WELDING PREPARATIONS MAY BE SUBJECT TO VARIATION DEPENDING ON WELDING PROCEDURES AGREED WITH THE COMPANY.
6- ALL WELD PROFILES SHALL CONFORM TO THE REQUIREMENTS OF THE APPROPRIATE FABRICATION SPECIFICATION.
7- WELD PROFILE RADIUS INDICATE THE REQUIRED AVERAGE AS WELDED SHAPE ONLY AND DO NOT CALL FOR SURFACE GRINDING UNLESS SPECIFIED ELSEWHERE.
8- THE MAXIMUM BUTT WELD REINFORCEMENT 'C' SHALL NOT EXCEED THE FOLLOWING

9- ALL BEVELS SHALL BE INDIVIDUALLY 20°, 30°, 45° WITH REGARD TO THE UT INSPECTION SURFACE.

5 DETAIL
SCALE : NONE
CORNER



* ANGLE VALUE MANDATORY

TYPICAL WELDING DETAILS
PLATE
SINGLE SIDED WELDS
FOLIO 7